

Work Order ID 127962

127962

Page 1

Item ID: D412-666-011BK

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Gross Weight Towing Adapter (Black)

Stop ***NS2***

Start Date: 12/18/14 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 12/26/14 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-666	Rev C1	<i>* SP</i>						<i>MLJ 15-03-25</i>	<i>[Signature]</i>
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP412-666-011	CHG 004							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAR 30 2015

4x

DAS
26
9-89

MAR 25 2015

4x

DAS
26
9-89

MAR 25 2015

DAS
46
9-89

MAR 30 2015

4x

DAS
26
9-89

Work Order ID 127962

127962

Page 2

December-18-14 9:58:08 AM

Item ID: D412-666-011BK Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gross Weight Towing Adapter (Black)
 Start Date: 12/18/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/26/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-666-011 Location: <u>023</u>								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

4
MAR 30 2015

DAS
06
9-89

MLJ 15-03-31

APR 5-3-30

Picklist Print

December-18-14 9:58:07 AM

Page 1

Work Order ID: 127962

127962

Parent Item: D412-666-011BK

D412-666-011BK

Parent Item Name: Gross Weight Towing Adapter (Black)

Start Date: 12/18/14

Required Date: 12/26/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B Added GHG 002 NG 02-03-06
IPP Rev:C As per Rev C JLM 07-09-07 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN6-15A 4 *AN6-15A* Bolt		Purchased	No			110	Each	40.0000	4	16			DAS 46 9-89

Location

Loc Qty

Loc Code

ST334

40

M126175

10

M128739

30

AN6-45A

Purchased

No

110

Each

11.0000

4

16

**

DAS
46

Bolt

Location

Loc Qty

Loc Code

ST333

11

M126180

11

D2888

Manufactured

No

110

Each

16.0000

2

8

**

DAS
46

Lug

Location

Loc Qty

Loc Code

ST527

16

107971

6

114023

2

120184

8

MAR 25 2015

Picklist Print

December-18-14 9:58:08 AM

Page 2

Work Order ID: 127962

127962

Parent Item: D412-666-011BK

D412-666-011BK

Parent Item Name: Gross Weight Towing Adapter (Black)

Start Date: 12/18/14

Required Date: 12/26/14

Start Qty: 4.00

Required Qty: 4.00

MS21042L6

Purchased

No

110

Each

144.0000

16

MS21042L6

Nut

**

DAS

46

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST305

144

m129909

38

m130582

6

m130799

100

110

Each

418.0000

NAS1149D0663J

Purchased

No

NAS1149D0663J

Washer

**

DAS

46

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST269

418

M126334

418

MAR 25 2015

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

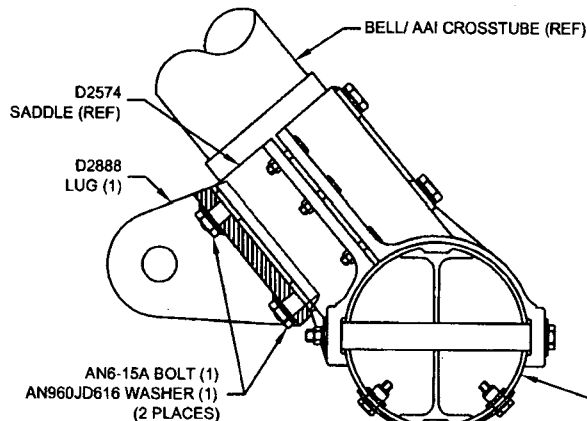


FIGURE 1
(BELL/AAI CROSSTUBES)

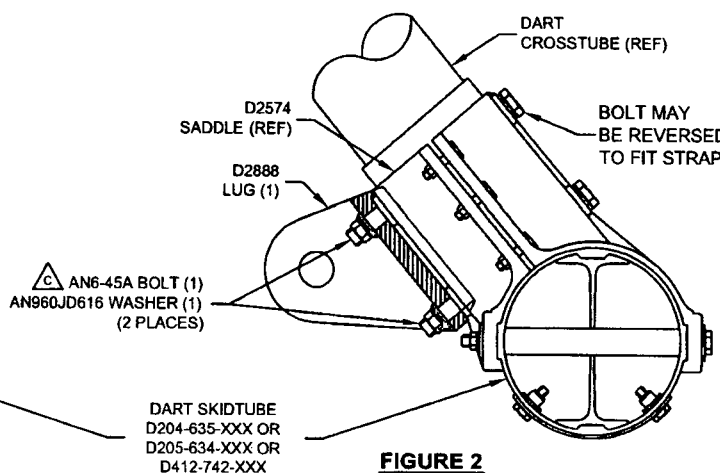


FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JA		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-666	SHEET 1 OF 1
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	412 GROSS WEIGHT TOWING KIT	1:4
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